

D3687-1

Work Order ID: 81748

B81748

81748

Page 1

March-16-12 3:20:32 PM

Item ID: D3687-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: MOUNT

Start Date: 16/03/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 23/04/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: MCT

Date: 12/03/19

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3687

Rev C

100

0.00

100

Outsource1

Memo

0.00

Outsource process - Heat Treat

Send M174B3937X4750 For heat treating
to CONDITION H-900 (to become M174PHH900B3937X4750)
FTU IN EXCESS OF 190 KSI
FTU IN EXCESS OF 170 KSI

CERTIFICATE IS REQUIRED

105

0.00

105

Outsource5

Memo

0.00

Outsource process - Machining

Issue P/O: 16478
Machine as per Dwg D3687
Possible Supplier: Globus Precision
Conformity sheet required

CL 12/03/19 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81748

March-16-12 3:20:32 PM

81748

Page 2

Item ID: D3687-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: MOUNT
 Start Date: 16/03/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 23/04/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 *110*	Receive & Inspect for Damage & Mat'l Certs	0.00							
Packaging	Memo	0.00							
Packaging	Ensure certificate of conformity is attached								
120 *120*	QC Inspect dimensions to drawing	0.00							
QC	Memo	0.00							
Quality Control	INSPECT HOLE ALIGHMENT USING DT9707 JIG								
124 *124*		0.00							
Purchasing	Memo	0.00							
Purchasing	Issue P/O FOR LIQUID PENETRATION P/O #: 22148								
	Certificate of conformity is required								

42/3/12 (4)

7b →

DAS
27
9-89
13/11/21

4

Q2 13/11/22 (4)

See pink NCR

W/O: 81748

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: 3687-1

PAR #: _____

Fault Category: SyolusNCR: Yes NoDQA: OKDate: 13/12/05

13-3285

Resolution: _____

Disposition: RTU SCRAPQA: N/C Closed: OKDate: 11/12/03

NCR: 81748

WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/01/08	#1 105	Found at inspection that Qty 3 out of 4 do not match the drawing. All on each part are three 0.623" diameters are too big at base of the post. 0.626-0.628"	S 13/11/22 027-012	Return to Anchor For Re-machining	S 13/11/22	DAS 27 9-89 13/11/21	S 13/11/22	S 13/11/22
		R.C. not machined correctly by supplier.	Ju	R.C. tool wear / only checks old stock - cannot				
				be re-machined: chee	13/12/03	X 689.85 3069.55		

NOTE: Date & initial all entries

Work Order ID 81748

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March-16-12 3:20:32 PM

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 Item Name: MOUNT
 Start Date: 16/03/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 23/04/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
125 *125* Packaging Packaging	Receive & Inspect for Damage & Mat'l Certs Memo ENSURE NDT RESULT IS ATTACH	0.00 0.00							<u>13/11/22</u> (4)
126 *126* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							<u>4</u>
127 *127* QC Quality Control	QC6- Inspect dimensions to drawing Memo DIMENSIONAL CHECK, ENSURE THAT BOLT HOLES ARE CORRECT SIZE	0.00 0.00							<u>4</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 81748

March-16-12 3:20:32 PM

81748

Page 4

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>GA</u>	0.00							
130									
Packaging	Memo	0.00				4X	DAS 28 9-89	13-11-27	
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

13/11/29 *[Signature]*

UKE

13-11-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March-16-12 3:20:35 PM

Page 1

Work Order ID: 81748

81748

Parent Item: D3687-1

D3687-1

Parent Item Name: MOUNT

Start Date: 16/03/2012

Required Date: 23/04/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 08-01-15 JLM Verified By:EC
IPP Rev:B Added Contion H-900 JLM Verified By:DD IPP REV
C: ADDED QC6 10.09.09 JLM VERIFIED BY DD
IPP REV D:ADDED DT9707 INSPECTION JIG 11-01-05 JLM VERIFIED
BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M174PH- H900B3.937X4.750		Purchased	No			100	f	5.3000	0.33333	1.33332			

M174PH-H900B3 937X4 750

17-4SS Bar H900-3.937x4.750

**

CL 12/03/20

Location

Loc Qty

Loc Code

MAT005

5.3

112374

5.3

D3687-1P

Purchased

No

105

Each

0.0000

1

4

D3687-1P

MOUNT

**

CL 12/03/17 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

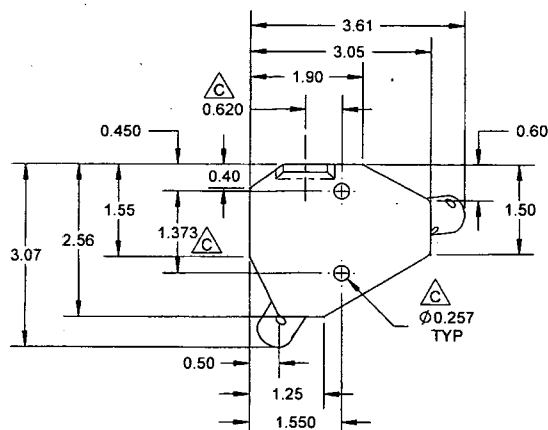
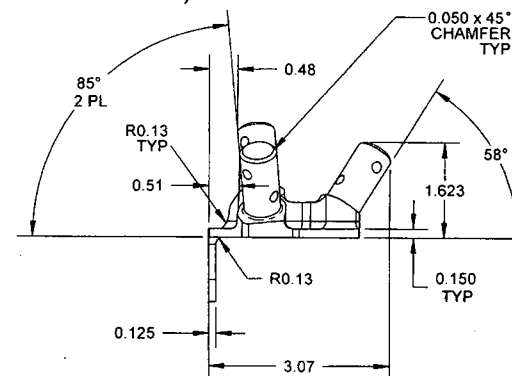
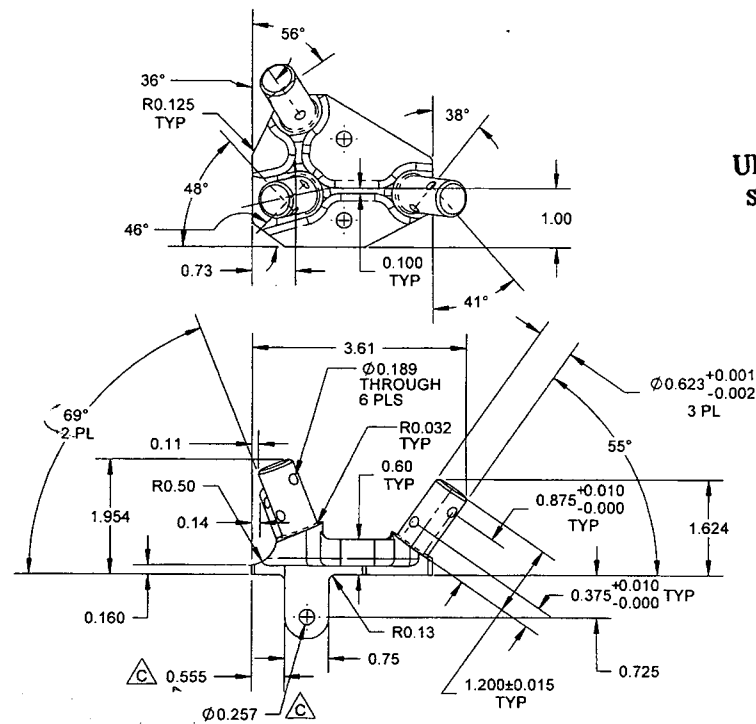
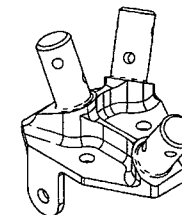
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

MLJ
12/03/19



D3687-1 MOUNT

NOTES:

- 1) MATERIAL: 17-4PH SS BAR PER AMS 5643, H-900 CONDITION
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.81 lb
- 8) LPI PER QSI 038 4.1.1 (ASTM E1417 LEVEL 2)

C	0.555 WAS 0.50 (ZN B8-1); 1.373 WAS 1.375 (ZN A8-1, A8-2); ADD 0.620 (ZN B7-1) PER INFORMATION; UPDATE NOTE 8 TO REF QSI (ZN A6-1, B3-2); Q0.257 WAS Q0.250 (ZN A6-1, B7-1, B7-2)	RF	09.08.26
B	CHANGE TO 17-4PH H-900 (ZN A6-1 & B3-2); R0.032 WAS R0.015 (ZN C7-1 & C7-2); REFORMAT TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.03.12
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>9/</i>	DRAWING NO.	REV. 0
MFG. APPR.	<i>2/</i>	D3687	SHEET 1 OF 1
APPROVED	<i>1/</i>	TITLE	SCALE
DE APPR.	<i>1/</i>	MOUNT	NTS
DATE	09.08.26	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON OR ORGANIZATION WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	

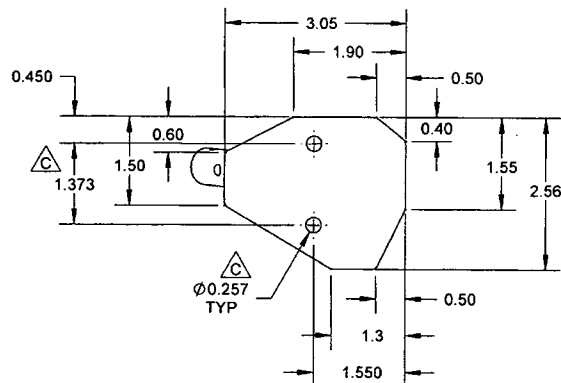
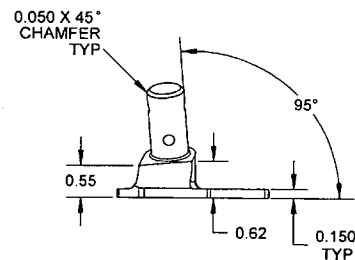
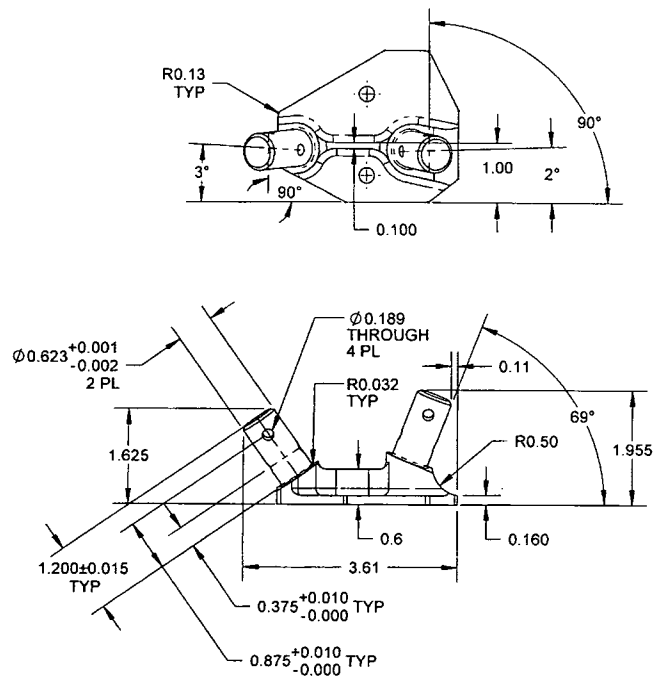
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



- NOTES:
- 1) MATERIAL: 17-4PH SS BAR PER AMS 5643, H-900 CONDITION
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.64 lb
 - 8) LPI PER QSI 038 4.1.1 (ASTM E1417 LEVEL 2)

D3687-3 MOUNT

RELEASED
2009-08-22

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	GP	DRAWING NO.	REV. C
MFG. APPR.	GP	D3687	SHEET 2 OF 2
APPROVED	GP	TITLE	SCALE
DE APPR.	H	MOUNT	NTS
DATE	09.08.26	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Receiving Report

Date: 09/08/06

Batch No: M112374

Supplier: Ymagu

Dart P/O: 10117

Packing Slip: Yes ☒ No ☐
 Invoice: Yes ☐ No ☒
 Receipt: Cash ☐ Cr ☐

Release Note Attached: Yes ☐ No ☐ N/A ☐
 Waybill Attached: Yes ☐ No ☐ N/A ☐
 Shipment Complete: S Yes ☒ No ☐ N/A ☐
 QC6 Inspection 09/05/21 N/A ☐
 Work Order 09/05/21 N/A ☐

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12 CL

Production/Admin:

Date

Received/Costing

Initial

08/09/19
RL 10117
CL

Location

**Magna Stainless**

5775 Kieran St. Saint-Laurent QC H4S 0A3
Phone: (514) 339-1211 Watts: 1-800-363-6646 Fax: (514) 339-1105

INVOICE

Pg 1 of 1 I014724

SOLD TO:

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY , ON
K6A 1K7

RECEIVED**JUL 31 2009**

SHIP TO:

METCOR
560 BOUL ARTHUR SAUVE
SAINT-EUSTACHE, QC
J7R 5A8

MTR:Y

INVOICE DATE:	07/27/09
ORDER DATE:	07/22/09
SHIP DATE:	07/27/09
ORDER NUMBER:	W016184
PURCHASE ORDER:	P010117

Currency		Sales Person		Ship Via		F.O.B.		Terms	
CANADIAN DOLLARS		ERYCK BLAIS		NIR:R-557065-1		PREPAID		NET 30 DAYS	
Ln.	Back Ordered	Ordered	Unit	Description		Shipped	Price Per	Value	
		2	PC	STAINLESS - LB 17-4 PH 3.937 X 4.750 X 9' L029745 2 PC/1,201 LB PLEASE CUT BAR IN HALF		2 UN	4,310.00	8,620.00	
		4	PC	STAINLESS ROUNDS SRB 17-4 ANN 1" x R/L L025718 12'7" 4 PC/134 LB PLEASE CUT ALL INTO 4' LG PIECES PLUS DROPS MUST BE SPEC AMS 5643		4 UN	135.00	540.00	
		2	PC	SRB 17-4 ANN 1-3/8" x R/L L029746 12'5" 2 PC/124 LB PLEASE CUT ALL INTO 4' LG PIECES PLUS DROPS MUST BE SPEC AMS 5643		2 UN	280.00	560.00	

07/28/09 13:22:01

Merchandise:	9,720.00
Surcharges:	
No Tax Costs:	
GST	486.00
PSTQ	765.45
Total Due:	10,971.45

Title to the goods sent out on this invoice remains with Magna Stainless Div of CSM ULC until such time as this invoice has been paid in full. Unless otherwise noted terms are 30 days. Interest accrues on all overdue accounts at the rate of 1.5% per month compounded monthly.

Q.S.T. # 1213236471
G.S.T. # 881565899 RT0001

Purchase Order Receipt Listing

Page 1 of 1

August 19, 2009 3:06:10 PM

All amounts are calculated in domestic currency.

All Vendors PO ID PO10117 All Receipt Dates All Line Item Types
All Item ID/GL/WOs All Rec. Employees All Currencies
Grouped by Vendor ID

Purchase Order ID/ Curr Type	Line Nbr/ Insp Req	Project ID	Reference/ Description/ Cert Std	PO U/M / Stock U/M	Required Date Required Qty	Recv Date/ Recv Emp	Recv Qty (PO U/M)	Cost Per Unit/ Recv Value	Inspected Qty/ Rejected Qty (PO U/M)	MRB Qty/ MRB Reject Qty	Book Amt
VendorID\Vendor Name		VC-MAG002	Magna Stainless								
PO10117	1		M174PH-H900B3.937X4.750	f	7/27/09	8/19/09	19.0277	\$478.89	0.0000	0	\$9,112.18
CAD	No		17-4SS Bar H900-3.937x4.750 112374	f	18.0000	LAVO01		\$9,112.18	0.0000	0	
	2		M174PH-H900R1.000	f	7/22/09	8/19/09	44.0000	\$13.50	0.0000	0	\$594.00
	No		17-4SS H900 ROUND BAR 1.00 112374	f	40.0000	LAVO01		\$594.00	0.0000	0	
	3		M174PH-H900R1.375	f	7/22/09	8/19/09	24.0000	\$28.00	0.0000	0	\$672.00
	No		17-4 SS H900 ROUND BAR 1.375 112374	f	20.0000	LAVO01		\$672.00	0.0000	0	



Magna Stainless

3775 Marsh St. Saint-Laurent, Qc. H4S 0A3
Phone: (514) 339-7219 Fax: (514) 339-5445

PACKING LIST

T014724

Page 1 of 1

SHIP TO:
DART AEROSPACE LTD
1200 ABERDEEN STREET

SHIP TO:
METCOR
550 BOUL ARTHUR VALLEE

SHAWNEEBURG
R6A 1N6
ONTARIO CANADA

SAINT-EUSTACHE QC
J3R 4A8
BILL TERMS: PREPAID



SPECIAL INSTRUCTIONS

Currency	Sales Person	Customer Phone	Customer Fax	Customer PO	
CANADIAN DOLLARS	KRYOR BLAIS	(514) 339-5200	(514) 339-1050	E910117	
Sales Order	Terms	Ship Via	Date Ordered	Date Required	Date Shipped
MO14784	NET 30 DAYS	NIR R-557065-1	07/22/09	07/27/09	07/27/09

Ordered	Back Ordered	Unit	Description	Bundle #	Heat #	Shipped
2		PC	STAINLESS - 1B 12 7" 114 LB / 4 PC		10317	2
		PC	PLEASE CUT BAR IN HALF		203548	2
		PC	STAINLESS ROUNDS 12 7" 114 LB / 4 PC		247478	4
		PC	PLEASE CUT ALL INTO 4 1/2" PIECES PLUS CROPS MUST BE SPEC AND 5643			2
		PC	STAINLESS ROUNDS 12 7" 114 LB / 4 PC		247478	4
		PC	PLEASE CUT ALL INTO 4 1/2" PIECES PLUS CROPS MUST BE SPEC AND 5643			2
Total weight						1.459 LB

Received by:

Date:

Signature:

08/20/2009 THU 16:30 FAX 5143352202 Magna Stainless Admin

002/007



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PO REPRINT

Purchase Order ID PO10117

Purchase Order Date 7/22/09

PO Print Date 7/22/09

Page Number 1 of 1

Order From :
MAGNA STAINLESS
5775 RUE KIERAN
ST LAURENT, QC H4S 0A3
CA

VC-MAG002

Contact Name
Vendor Phone 800 363 6646
Vendor Fax 514 339 1105

Buyer
Requisition Nbr
Tax Resale Nbr 10127-2607

Vendor Account Nbr

Terms Net-30

Currency CAD

FOB

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req. Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	M174PH-H900B3.937X4.750 C209108107	17-4SS Bar H900- 3.937x4.750	7/27/09 Yes	19.25' total Rec'd 19.3333 f	Epic collect	\$478.8900	\$8,620.02
2	M174PH-H900R1.000 rec'd 48 C209108107	17-4SS H900 ROUND BAR 1.00	7/22/09 Yes	40.00 f	Epic collect	\$13.5000	\$540.00
3	M174PH-H900R1.375 rec'd 24 C209108107	17-4 SS H900 ROUND BAR 1.375	7/22/09 Yes	20.00 f	Epic collect	\$28.0000	\$560.00

Special Inst: ALL ABOVE: 17-4PH cond. H900
PER AMS 5643
PLEASE SHIP ALL ABOVE TO
METCOR INC
560 BOUL. ARTHUR SAUVE
SAINT-EUSTACHE, QC
J7R 5A8 (450-491-5498)
SHIP VIA EPIC EXPRESS OUR
ACCT # 4300450343

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

POSITIVE RECALL

EFFECTIVE 7/22/09

RELEASED 7/22/09

AUTH 7/22/09
DATE 7/22/09



PO Total:

\$9,720.02

Change Nbr: 2

Change Date: 7/22/09

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable

Metcor Inc.

Metcor Inc.
560, boul. Arthur-Sauvé
St-Eustache (Québec) J7R 5A8
Tél: (450) 473-1884
Fax Administration: (450) 491-5498
Fax Production: (450) 491-6454

Rapport d'inspection

Order	Load
149974	1

Customer: 216
DART AEROSPACE
1270 ABERDEEN
HAWKESBURY

ON K6A 1K7

Shipped To:
DART AEROSPACE
1270 ABERDEEN
HAWKESBURY

ON K6A 1K7

Customer PO / PO du Client	Customer Shipper No.	Material Type / Material	Mat'l Heat Code	Lot Number
10128		17-4PH		
PROCESSING SPECIFICATIONS				
AGE HARDEN CONDITION H900 SAS AMS 2759/3 REV E				
Requirement	Specified	Tests Performed	Test Results	
HARDNESS	40 - 47 HRC	28	43 - 45 HRC	
Quantity	Weight	Part Number / Part Description		
28	1447	BARRE RONDE 6 BARRES DE 7" + 18 BARRES DE 46" BAR 1" & 1.375" BARRE CARREE 4 BARRES DE 50" BAR 3.937 X 4.750 1 PALETTE		

COMMENTS

INSPECTOR: *SM*



DATE: 2009-08-04

FACSIMILE TRANSMITTAL

MAGNA
INOXYDABLE INC.

TO/À: Chantal

FAX #: ²
(613) 632-1053

CO: Dart Aerospace

DATE: Aug. 20/09

RE: PO # 10117

PAGES: 6 + COVER
+ COUVERTURE

FROM/DE: **BARRY MARTIN**

QUALITY MANAGER/GÉRANT À LA QUALITÉ

PHONE: (514) 339-1211

FAX: (514) 335-2202

E-MAIL: bmartin@magnastainless.com

5775 Rue Kieran St-Laurent Quebec H4S 0A3 TEL: (514) 339-1211 1 (800) 363-6646



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO16478

Purchase Order Date 3/19/12

PO Print Date 3/19/12

Page Number 1 of 1

Order From:

VC-GLO001

ARCHER PRECISION INC.
36 COLONNADE RD. N.
NEPEAN, ON K2E 7J6
CA

Contact Name

Vendor Phone

613 226 1579

Vendor Fax

613 226 1719

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To:

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAKED

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	D3687-1P	MOUNT	4/11/12 Yes	4.00 Each	FedEx PI collect	\$441.7000	\$1,766.80
			Special Inst:	AS PER DWG D3687 REV. C B81748			
2	D3687-3P	MOUNT	4/11/12 Yes	8.00 Each	FedEx PI collect	\$321.5010	\$2,572.01
			Special Inst:	AS PER DWG D3687 REV. C B81744			

PO Total:

\$4,338.81

Change Nbr: 1

Change Date: 3/19/12

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable



2228 Gladwin Cresent
Ottawa, Ontario
K1B 4S6

Phone # 613-899-2405

Packing Slip

Date	Invoice #
9/11/2012	236

Ship To
Main Finished Goods Location Dart Aerospace 1270 Aberdeen Street Hawksbury, Ontario K6A 1K7

P.O. No.	Ship	Via	FOB	Project
16478	9/11/2012	Federal Express	Archer	

Qty	Item Code	Description
4	Sales	D3687-1P HST (ON) on sales



2228 Gladwin Cres.
Ottawa, Ontario
K1B 4S6

Telephone (613) 899-2405
Fax (613) 226-1719

Certificate of Compliance

To:
Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury Ont.
K6A 1K7

Po Number	Part Number	Quantities
16478	D3687-1P	4
16829	D3687-1P	3

It is hereby certified that all articles mentioned above are in conformance with the requirements, specification and drawings as listed on customer purchase order number, 16478 and 16829 issued by Dart Aerospace Inc.

A handwritten signature in black ink, appearing to read "Alex Mazerolle", is written over a horizontal line.

Alex Mazerolle
President
Archer Precision Inc.
1393 Major Road,
Orleans Ontario
K1E 1H3

Inspection Report

ARCHER
PRECISION

Customer Name: **Dart Aerospace** QTY: **10** DWG #: **D3687** REV: **C** Part Name: **Mount** Date: **ASAP** Lot#: **514-1 + 603** Job #: **514-1 + 603**

Page 1 of **1** Inspection Interval: **PO # 16478** Special Notes: **AND # 16829**

Item #	DWG. Dim	Tolerance	Operator	QA First Off		QA Final		2	3	4	5	6	7	8	9	10
				First Off	A	R	A	R								
	Rev	C														
	MAT	17-4PH														
	SUB	None														
	Deburr	Yes														
1	.073	±.030	.737													
2	46°	±1/2°	PP													
3	48°	±1/2°	PP													
4	R.125	±.010	.125													
5	36°	±1/2°	PP													
6	56°	±1/2°	PP													
7	38°	±1/2°	PP													
8	1.00	±.030	1.005													
9	41°	±1/2°	PP													
10	0.100	±.010	.099													
11	0.160	±.010	.160													
12	1.954	±.010	1.953													
13	0.14	±.030	PP													
14	R0.50	±.030	PP													
15	69°	±1/2°	PP													
16	0.11	±.030	PP													
17	3.61	±.030	PP													
18	Ø0.189	±.010	.187													
19	6PL	-														
20	R0.032	±.010														
21	0.60	±.030	.598													

Date of Issue July, 13, 2005.

22	.00623	+0.001/- 0.002	.622	/	/	.6221	.6235	.6219	.6233	.623	.622
23	55°	±1/2°	PP	/	/	-	-	-	-	-	-
24	1.624	±0.010	PP	/	/	1.623	1.625	1.624	1.624	1.624	1.623
25	0.875	+0.010	.8755	/	/	.875	.875	.875	.875	.875	.875
26	0.375	+0.010	.3735	/	/	.374	.374	.374	.374	.374	.374
27	0.725	±0.010	.725	/	/	.724	.725	.724	.724	.725	.724
28	1.200	±0.015	1.200	/	/	1.200	1.201	1.200	1.200	1.200	1.200
29	0.75	±0.030	.751	/	/	.750	-	-	-	-	-
30	R.13	±0.030	PP	/	/	-	-	-	-	-	-
31	85°	±1/2°	PP	/	/	-	-	-	-	-	-
32	R0.13	±0.030	PP	/	/	-	-	-	-	-	-
33	0.51	±0.010	.516	/	/	PP	PP	PP	PP	PP	PP
34	0.48	±0.030	.486	/	/	PP	PP	PP	PP	PP	PP
35	0.050	±0.010	✓	/	/	-	-	-	-	-	-
36	45°	±1/2°	✓	/	/	-	-	-	-	-	-
37	58°	±1/2°	PP	/	/	-	-	-	-	-	-
38	1.623	±0.010	PP	/	/	-	-	-	-	-	-
39	0.150	±0.010	.150	/	/	.150	.150	.150	.150	.150	.150
40	R0.13	±0.010	PP	/	/	-	-	-	-	-	-
41	3.07	±0.030	PP	/	/	-	-	-	-	-	-
42	0.125	±0.010	.127	/	/	.126	.128	.127	.126	.125	.126
43	3.61	±0.010	PP	/	/	-	-	-	-	-	-
44	3.05	±0.010	3.052	/	/	3.052	3.052	3.051	3.052	3.05	3.052
45	1.90	±0.030	1.702	/	/	PP	PP	PP	PP	PP	PP
46	0.620	±0.010	.620	/	/	PP	PP	PP	PP	PP	PP
47	0.450	±0.010	.450	/	/	PP	PP	PP	PP	PP	PP
48	0.40	±0.030	.400	/	/	PP	PP	PP	PP	PP	PP
49	1.55	±0.030	PP	/	/	PP	PP	PP	PP	PP	PP
50	2.56	±0.030	2.561	/	/	2.563	2.561	2.56	2.562	2.563	2.561
51	3.07	±0.030	PP	/	/	-	-	-	-	-	-
52	0.50	±0.030	PP	/	/	-	-	-	-	-	-
53	1.25	±0.030	PP	/	/	-	-	-	-	-	-
54	1.550	±0.010	PP	/	/	-	-	-	-	-	-

Date of Issue July.13 2005.



skyservice
Air travel. Evolved.

NDT Work Order

Sky Service F.B.O. Inc.

DOT APP 53-89 / EASA 145.7142 / BDA AMO 385

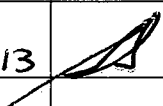

WO #: YYZ	70254	Customer: DART AEROSPACE	Dept: NDT YYZ	Reference: P022148
Make:		Model:	Reg:	A/C S/N:
TSN:		CSN:	TSO:	Tail#:

Task: ☐ Scheduled ☐ Unscheduled ☐ A.O.G. ☒ X.P.T. ☐ M.T. ☐ E.T. ☐ U.T. ☐ R.T.

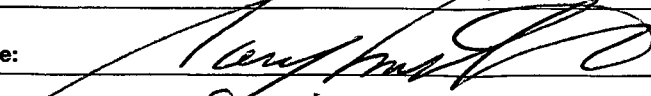

Work Required:

CARRY OUT NDT ON THE FOLLOWING ITEMS:

- ① MOUNT ID D3687-3, WO 83611 QTY-4
- ② MOUNT ID D3687-1, WO 81748 QTY-4
- ③ MOUNT ID D3687-1, WO 83609 QTY-1
- ④ CROSSTUBE ID D412-664-105, WO'S 101997, 101996, 101998
- ⑤ CROSSTUBE ID D412-664-209, WO'S 101749, 109058, 109059

Action Taken:	Date:	Initial/Stamp:
LIQUID PENETRANT INSPECTION CARRIED OUT ON ALL 15 ITEMS LISTED ABOVE	21 NOV 2013	 
No CRACKS FOUND		
PENETRANT - ARDROX 970P25E BATCH TPO10484		
BLACK LIGHT M 20189		

I certified that the maintenance described above has been performed with the applicable standard of airworthiness.

Signature: 	ACA/SCA Stamp	Date:
Name: GARY SMITH		21 NOV 2013